

Date: Tuesday, 28/10/2008 3:41:02 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SLEEVE
Job Number : 43036	
Estimate Number : 13330	
P.O. Number :	Part Number : D37861
This Issue : 28/10/2008 S.O. No. :	Drawing Number : D3786 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 40981	Material :
Written By :	Due Date : 15/11/2008 Qty: 30 Um: Each
Checked & Approved By : <u>DD 08.10.29</u>	
Comment : Est Rev:A - 08-05-20 new issue DD verified by:EC Est Rev:B - 08-06-17 rev.A as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 0.1750 f(s)/Unit Total: 5.2511 f(s)

6061T6 TUBE

batch: M109854SA 08/11/205.5ft

2.0	DOOSAN LATHE	DOOSAN LATHE
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**Comment:** DOOSAN LATHE1- Turn as per Folio FA747 Rev: NA & Dwg D3786 Rev: A

2-Deburr per dwg D3786

SA 08/11/2030

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINESA 08/11/2030

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKSA 08/11/2030

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/11/2230X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 28/10/2008 3:41:02 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLEEVE

Job Number: 43036

Part Number: D37861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



W 08 11 22

(30)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

0118

C 08/11/24 (30)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/24 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF- 08-11-24

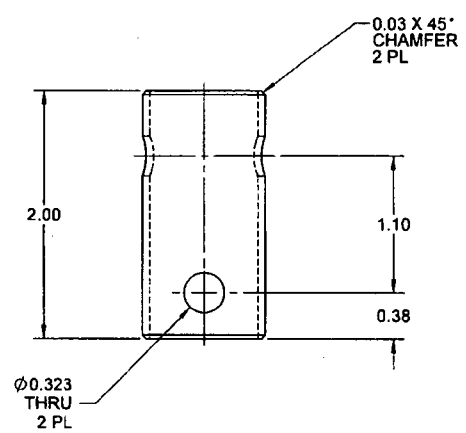
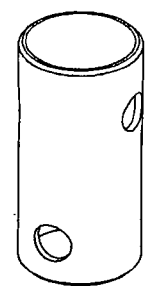
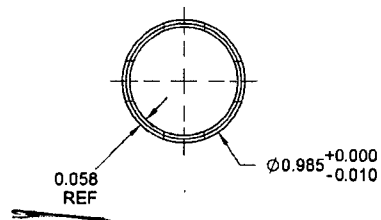
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3786-1 SLEEVE

RELEASED
08-06-04

SHOP COPY
ENGINEERING
RETURN TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 130030

- NOTES:
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000 X 0.065 WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs

A NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. D3786	REV. A
MFG. APPR.			SHEET 1 OF 1
APPROVED		TITLE SLEEVE	SCALE NTS
DE APPR.			
DATE	08.06.04		

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